



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

P.M.A.

D350-636-017
Job Sheet 186803



Part No: D350-636-017

Job Qty: 1 ea

Part Name: Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/17/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG d4168-043 rev.c IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 11.04.16 AS PER ECN 12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S131348



Part: D350-636-017

Job No: 186803

Serial No/Batch: S131348

Revision: C

Inspector:

Exp Date:

Instructions: TC STC SH99 - 7 Issue 2 of 2

2 of 2 EASA STC SR00646SE 15/10/28, EASA STC



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

P.M.A.

D350-636-017
Job Sheet 186803



Part No: D350-636-017

Job Qty: 1 ea

Part Name: Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/17/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG d4168-043 rev.c IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC
IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC
IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD
VERF:JFS

Ship Via:

Bill of Materials

DART AEROSPACE
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 (613) 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S131348

Part: D350-636-017

Job No: 186803

Serial No/Batch: S131348

Revision: C

Inspector:

Exp Date:

Instructions: TC STC SH99 - 7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/17/18	0.00	0.00	Start Up Skidtubes-1		Start Up MGA
110	Skidtubes	1 pcs		12/17/18	0.00	4.65	Skidtubes-1		MGA, BE
120	QC	1 pcs		12/17/18	0.00	0.00	QC10		38 DAS
130	QC	1 pcs		12/17/18	0.00	0.00	QC5		9-89 38
140	HandFinish	1 pcs		12/17/18	0.00	0.88	HandFinish1		DAS 12/18/18
150	QC	1 pcs		12/17/18	0.00	0.00	QC7-2		60
160	Skidtubes	1 pcs		12/17/18	0.00	4.65	Skidtubes-2		TP-89 BE
170	QC	1 pcs		12/17/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs		12/17/18	0.00	0.00	QC5		9-89 38
190	HandFinish	1 pcs		12/17/18	0.00	0.88	HandFinish2		DAS 12/18/18
200	SprayPaint	1 pcs		12/17/18	0.00	0.79	Spray Paint		DAS 12/18/18
210	QC	1 pcs		12/17/18	0.00	0.00	QC14		DAS 12/18/18
230	HandFinish	1 pcs		12/17/18	0.00	0.88	HandFinish4		BE 12-18 DAS
240	QC	1 pcs		12/17/18	0.00	0.00	QC5		DAS 12/18/18
250	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging1-3		69 9-89
260	QC	1 pcs		12/17/18	0.00	0.00	QC4		DAS 12/18/18
265	DC	1 pcs		12/17/18	0.00	0.00	DC		21-89 DAS
270	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging3-1		DAS 12/18/18
280	QC21-FG	1 Ea		12/17/18	0.00	0.00	QC21		21 9-89

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
 Descriptions: D4168-3 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
 then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER

POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes using drill Jig
 DT8150 & DT8864A for first side only DT8864B for second side. 4- Locate DT8330 off of blade fitting bolt holes and drill
 pilot holes for blade fitting 6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.
 7-Open up holes of Detail S to 0.297" (total of 2 holes per side) +.201"(total of 1 per side) 8-Weld D2744 Cap as per Dwg
 D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 138673 9-Grind
 welds flush as per Dwg D4168

120 - QC10- Inspect visual per QSI004- ground welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - 1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg
 D4168. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float
 hole using uni-bit to 0.500" (4 per side) 4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168
 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove
 alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: M138943
 exp. date: 19/03/06 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3
 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 138673 9- At
 section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flus

170 - QC10- Inspect visual per QSI004- ground welds

180 - QC5- Inspect part completeness to step on W/O

190 - Pressure Wash per QSI005 4.3 Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - Spray Painting per QSI005 4.2 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349

BATCH: 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 20042028

210 - QC14- Inspect Spray Paint Inspect for foreign object per QSI 024

230 - Assemble as per dwg 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-
 041, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5128386 EXP

DATE: 19/03 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube

batch: M138843 5-Coat all exposed fasteners with "LPS Procyon" batch: M133690

240 - QC5- Inspect part completeness to step on W/O

250 - Pick Kit

260 - QC4- 100% Inspect kits for completeness *****ensure antiseize is on AN8C21A bolts*****

265 - Document Control Photocopy blue file and type labels per PPP D350-636-017 CHG 006

270 - Identify as per dwg & Stock Location: Identify and pack for shipping as per PPPD350-636-017 Location :
 FG071

280 - QC21- Final Inspection - Work Order Release

1-88
DAS
1-88

1-88
DAS
1-88
1-88
DAS
1-88
1-88
DAS
1-88

1-88
DAS
1-88

1-88
DAS
1-88

1-88
DAS
1-88

M.H. 007068

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 Ea (1 ea)	90-Start up Operation	5109648
D2744	Cap	1 Ea (1 ea)	90-Start up Operation	5060499
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5126363
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5133720
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5082748x3 5132798x1
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-HandFinish	5058138
AN3C34A	Bolt	1 Ea (1 ea)	230-HandFinish	5137390
AN3C36A	Bolt	4 Ea (4 ea)	230-HandFinish	FM136658-1
AN3C37A	Bolt	1 Ea (1 ea)	230-HandFinish	5137392
AN3C42A	Bolt	1 Ea (1 ea)	230-HandFinish	5137393
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5049457-1
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5006333
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	5100398
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5128863
D3488-3	Blade Fitting, LH	1 Ea (1 ea)	230-HandFinish	5128414
D3490-5	Cross Bolt Spacer	4 Ea (4 ea)	230-HandFinish	5132494
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5127306
D3492-5	Plug	8 Ea (8 ea)	230-HandFinish	5102611 50 38391
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5058407
D3873-1	Bushing	7 Ea (7 ea)	230-HandFinish	5129302
D4154-041	Wearplate Assembly	1 Ea (1 ea)	230-HandFinish	5137397
D4170-1	Bushing	4 Ea (4 ea)	230-HandFinish	5131023
D4171-1	Bushing	1 Ea (1 ea)	230-HandFinish	5137399
MS21043-3	Nut	5 Ea (5 ea)	230-HandFinish	5083543-1
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5093614
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5090633
NAS1149C0332R	Washer	4 Ea (4 ea)	230-HandFinish	5130139
NAS1149C0363R	Washer	9 Ea (9 ea)	230-HandFinish	5137395
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	5076017-2
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083559
NAS1611-005	O-Ring	8 Ea (8 ea)	230-HandFinish	5057657
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5106792
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5079136
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5082286
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5125813
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5104046
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5089248

packaging <

007000

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-LH	1	14	0
	D2744	1	24	0
160-Skidtubes	D2739	1	18	0
	D2743	8	39	0
	D3490-1	4	23	0
230-HandFinish	ALS4-1032-225	4	1,319	0
	AN3C34A	1	20	0
	AN3C36A	4	500	0
	AN3C37A	1	87	0
	AN3C42A	1	42	0
	AN3C6A	4	177	0
	AN6C44A	4	103	0
	AN8C35A	1	34	0
	D2745	8	103	0
	D3488-3	1	10	0
	D3490-5	4	8	0
	D3492-1	8	73	0
	D3492-5	8	119	0
	D3631-1	8	411	0
	D3873-1	7	93	0
	D4154-041	1	4	0
	D4170-1	4	10	0
	D4171-1	1	12	0
	MS21043-3	5	852	0
	MS21043-6	4	109	0
	MS21083C8	1	121	0
	NAS1149C0332R	4	3,582	0
	NAS1149C0363R	9	199	0
	NAS1149C0832R	1	370	0
	NAS1515H3L	4	405	0
	NAS1611-005	8	303	0
	NAS1611-010	8	603	0
250-Packaging	AN8C21A	2	73	0
	D2741	1	85	0
	D3493-1	2	49	0
	MS21083C8	2	121	0
	NAS1149D0863J	2	72	0

Part Specifications

Specifications could not be found.

Plex 11/21/18 1:06 PM dart.white.jesse

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X					D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X				D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X			D4168-044	350 SKIDTUBE ASSEMBLY, RH
				X		D4168-051	350 SKIDTUBE ASSEMBLY, LH
					X	D4168-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG ASSEMBLY
8	8					D3492-043	PLUG ASSEMBLY
		8	8			D3492-045	PLUG ASSEMBLY
8	8	8	8	8	8	D3631-1	WASHER
7	7	7	7	7	7	D3873-1	BUSHING
1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1						D4168-1	SKIDTUBE WELDMENT, LH
	1					D4168-2	SKIDTUBE WELDMENT, RH
		1				D4168-3	SKIDTUBE WELDMENT, LH
			1			D4168-4	SKIDTUBE WELDMENT, RH
				1		D4168-5	SKIDTUBE WELDMENT, LH
					1	D4168-6	SKIDTUBE WELDMENT, RH
4	4	4	4	4	4	D4170-1	SPACER
1	1	1	1	1	1	D4171-1	BUSHING
4	4	4	4	4	4	ALS4-1032-225	INSERT
1	1	1	1	1	1	AN3C34A	BOLT
4	4	4	4	4	4	AN3C36A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN8C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
5	5	5	5	5	5	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
4	4	4	4	4	4	NAS1149C0332R	WASHER
9	9	9	9	9	9	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D4168-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.3
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 lbs
D4168-051/-052 = 31.9 lbs
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

C	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D4168-5/-6 (ZN B5-1, SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11, D2-12, D2-13, D2-14); ADDED NOTES 13, 14 (ZN C4-1); NAS1149C0363R WAS AN960C10 (ZN A5-1, C8-11, C7-11, D8-11, C8-12, C7-12, D8-12, C8-13, C7-13, D8-13, C8-14, C7-14, D8-14); NAS1149C0332R WAS AN960C10L (ZN B1-11, B1-12, B1-13, B1-14); NAS1149C0832R WAS AN960C816L (ZN C1-11, C1-12, C1-13, C1-14)	ZF	18.03.01
B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
DATE	18.03.01		

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D4168** REV. C
SHEET 1 OF 16
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

COPYRIGHT © 2016 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED

2018 OCT 19
2018-03-01

APPROVED

8 7 6 5 4 3 2 1

D

C

B

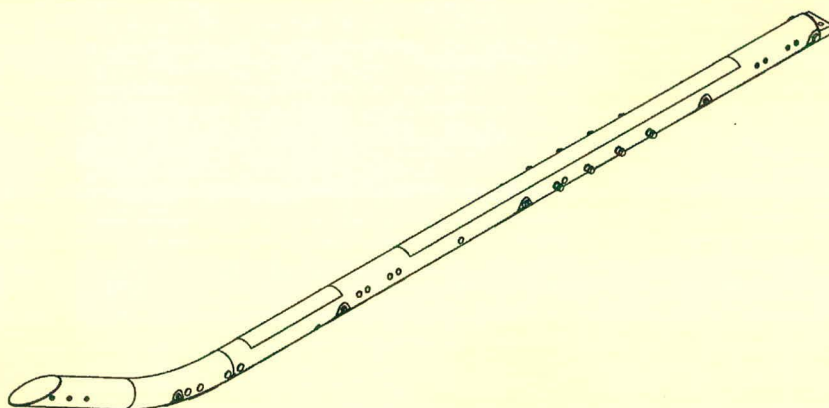
A

D

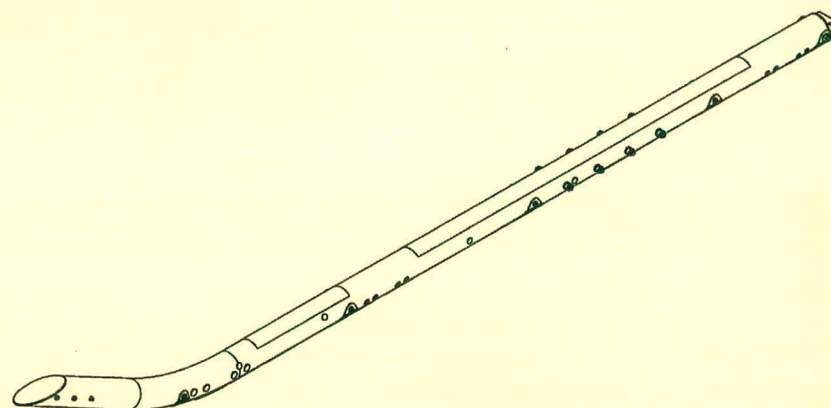
C

B

A



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED

2018 OCT 19

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 2 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

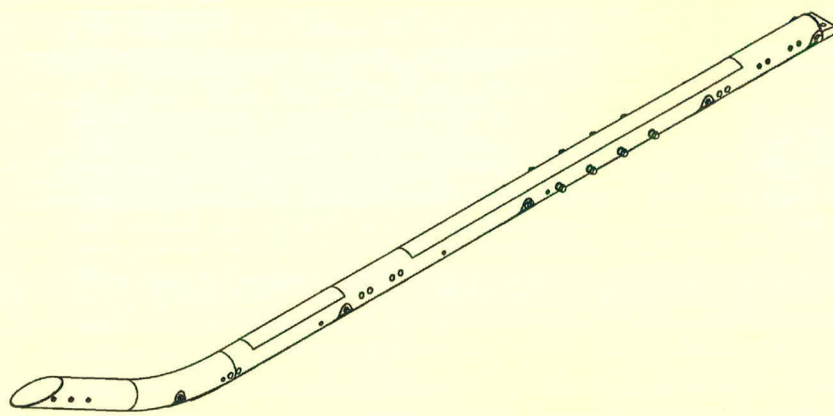
A

D

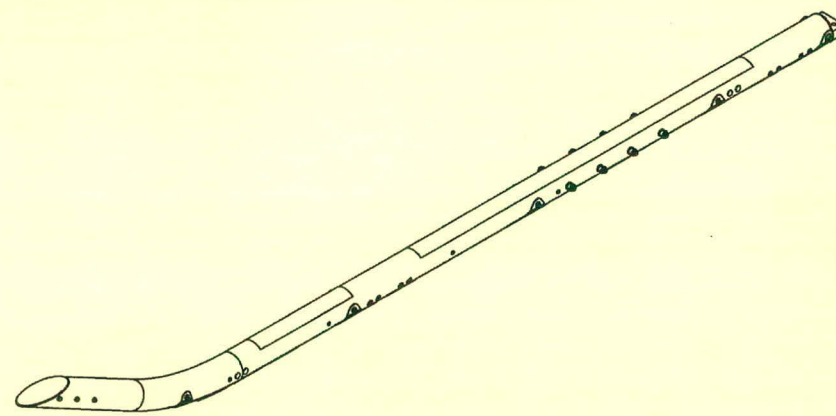
C

B

A



D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D4168	REV. C
MFG. APPR.	DD	SHEET 3 OF 16	
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

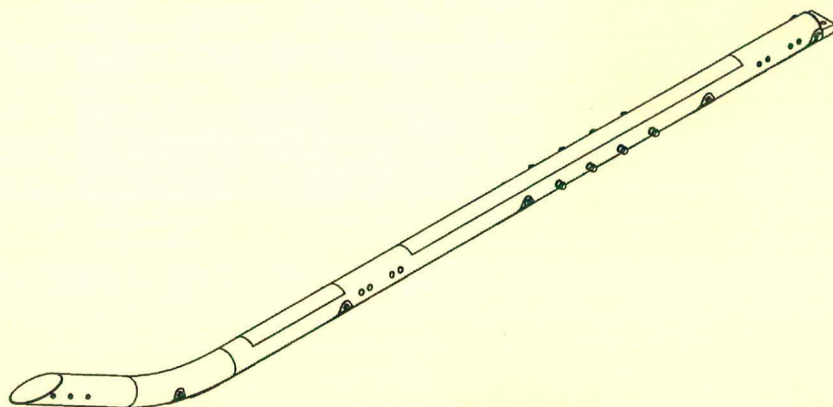
8 7 6 5 4 3 2 1

D

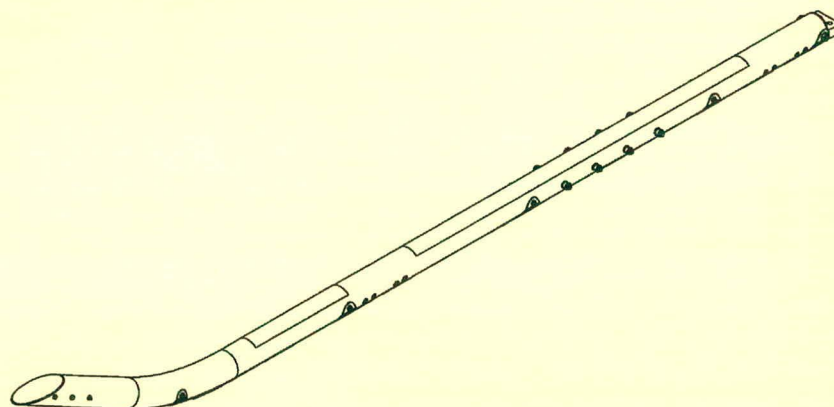
C

B

A



D4168-051 350 SKIDTUBE ASSEMBLY, LH



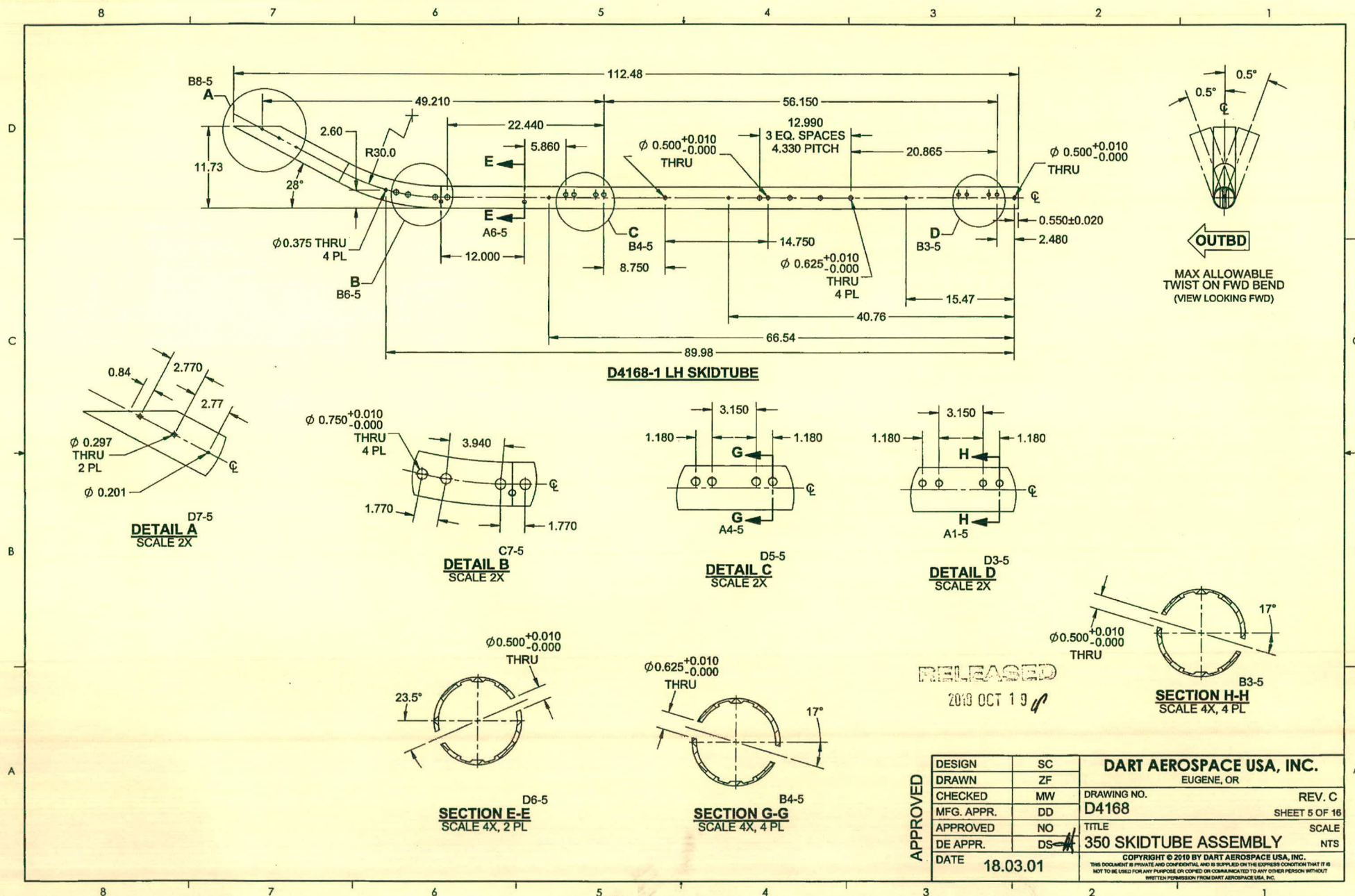
D4168-052 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2019 OCT 19

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 4 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

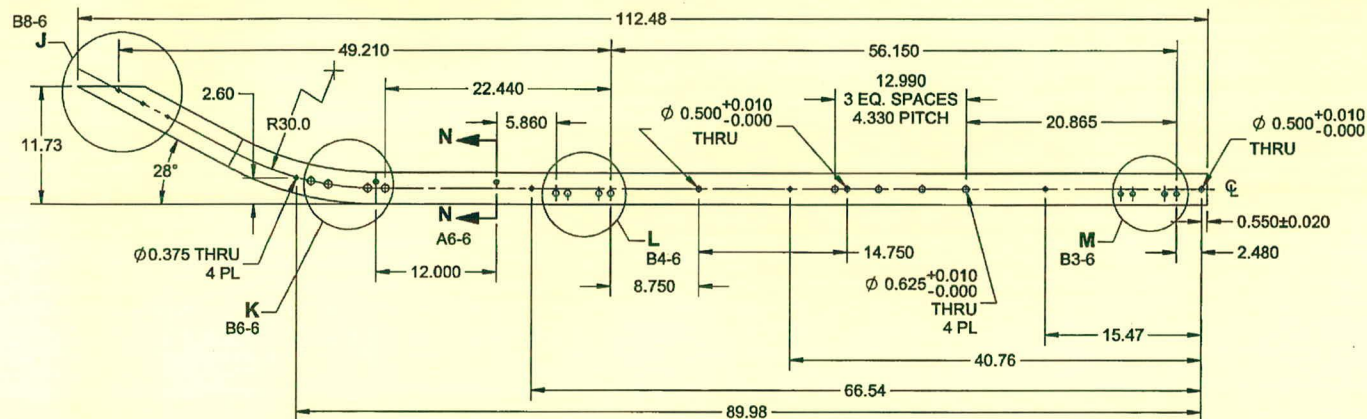
8 7 6 5 4 3 2 1



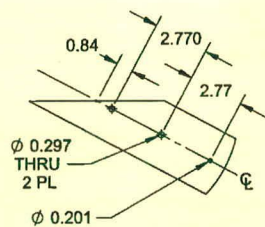
RELEASED

2019 OCT 19

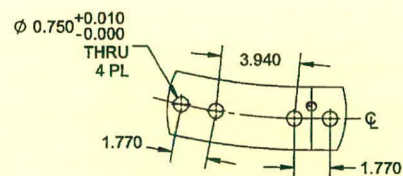
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D4168	REV. C
MFG. APPR.	DD	SHEET 5 OF 16	
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE 18.03.01		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



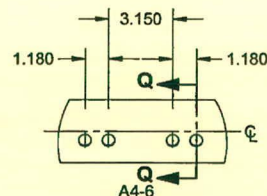
D4168-2 RH SKIDTUBE



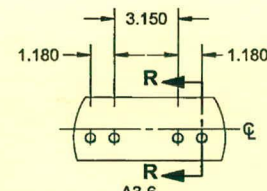
DETAIL J
SCALE 2X



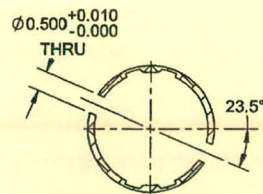
DETAIL K
SCALE 2X



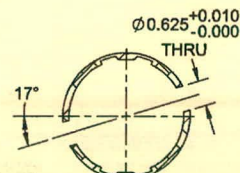
DETAIL L
SCALE 2X



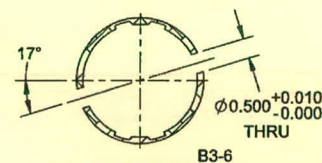
DETAIL M
SCALE 2X



SECTION N-N
SCALE 4X, 2 PL



SECTION Q-Q
SCALE 4X, 4 PL



SECTION R-R
SCALE 4X, 4 PL

RELEASED
2010 OCT 19

APPROVED

DESIGN	SC
DRAWN	ZF
CHECKED	MW
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.03.01

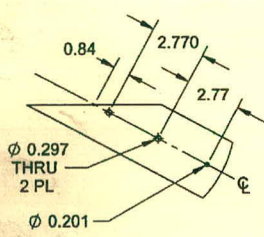
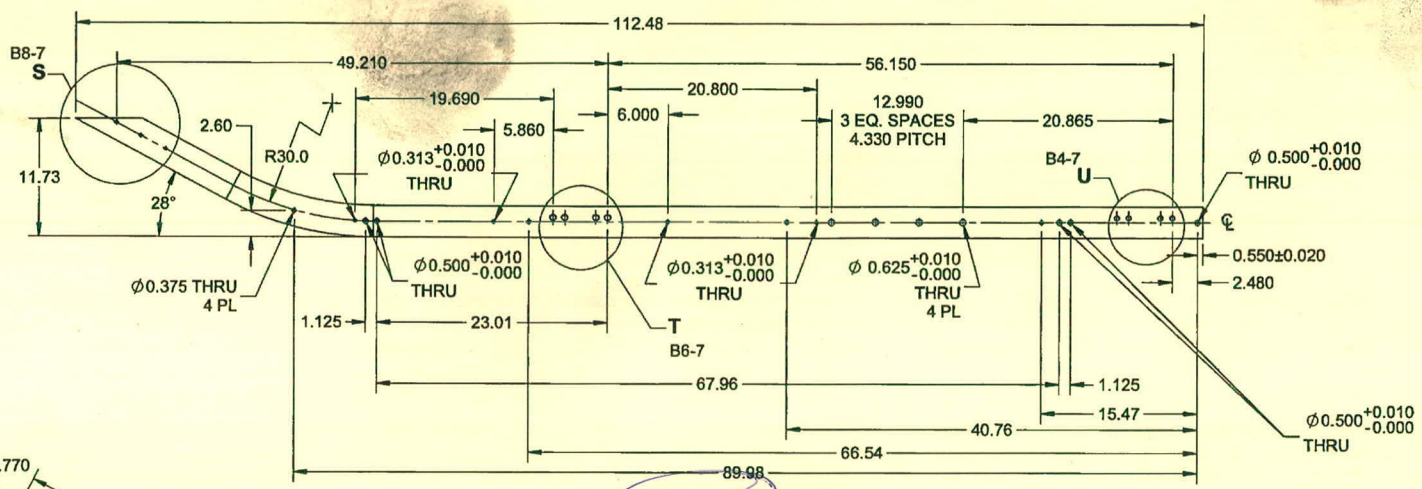
DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D4168** REV. C
SHEET 6 OF 16
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

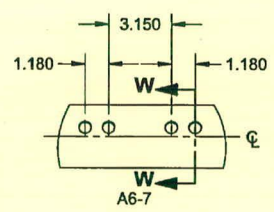
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



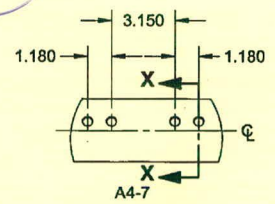
8 7 6 5 4 3 2 1



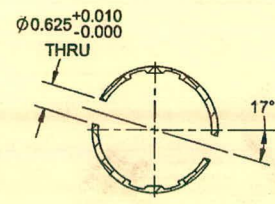
DETAILS
SCALE 2X



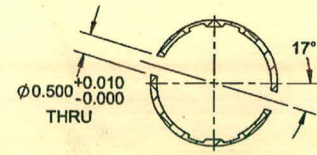
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 4X, 4 PL



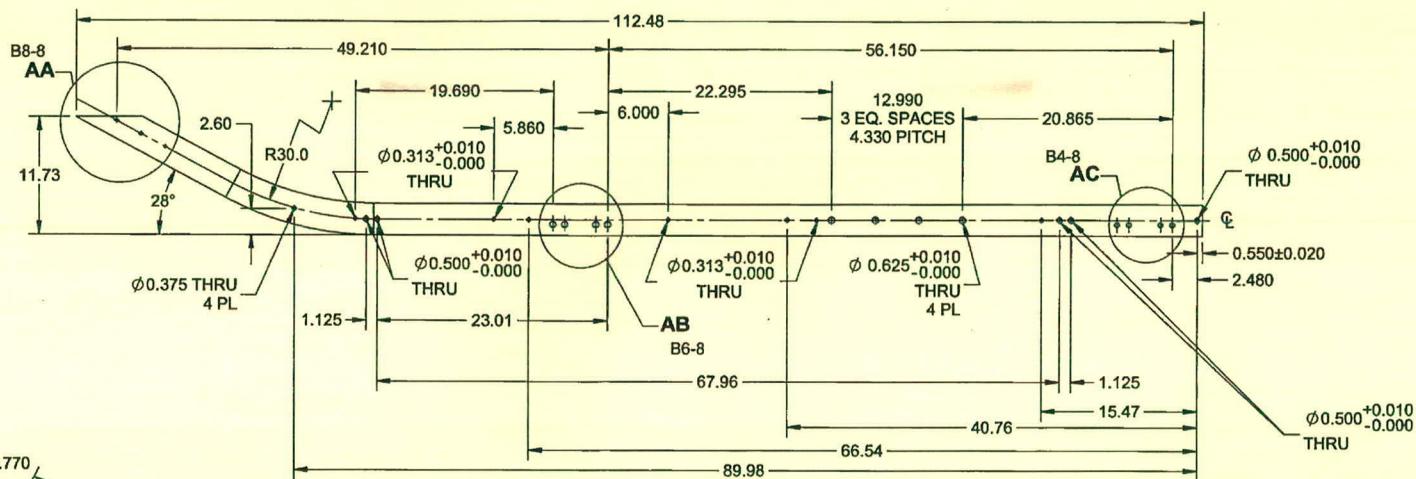
SECTION X-X
SCALE 4X, 4 PL

RELEASED
2019 OCT 19

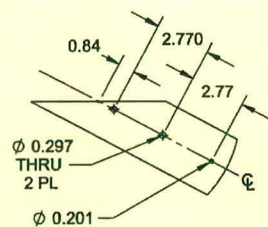
APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 7 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

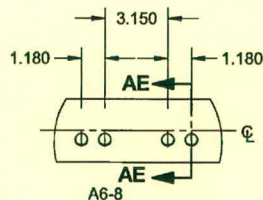
8 7 6 5 4 3 2 1



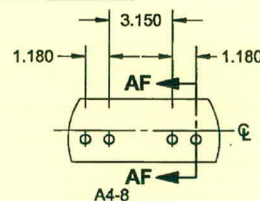
D4168-4 RH SKIDTUBE



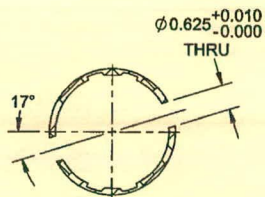
DETAIL AA
SCALE 2X



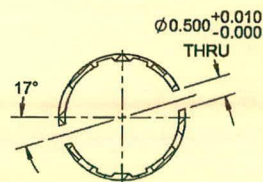
DETAIL AB
SCALE 2X



DETAIL AC
SCALE 2X



SECTION AE-AE
SCALE 4X, 4 PL



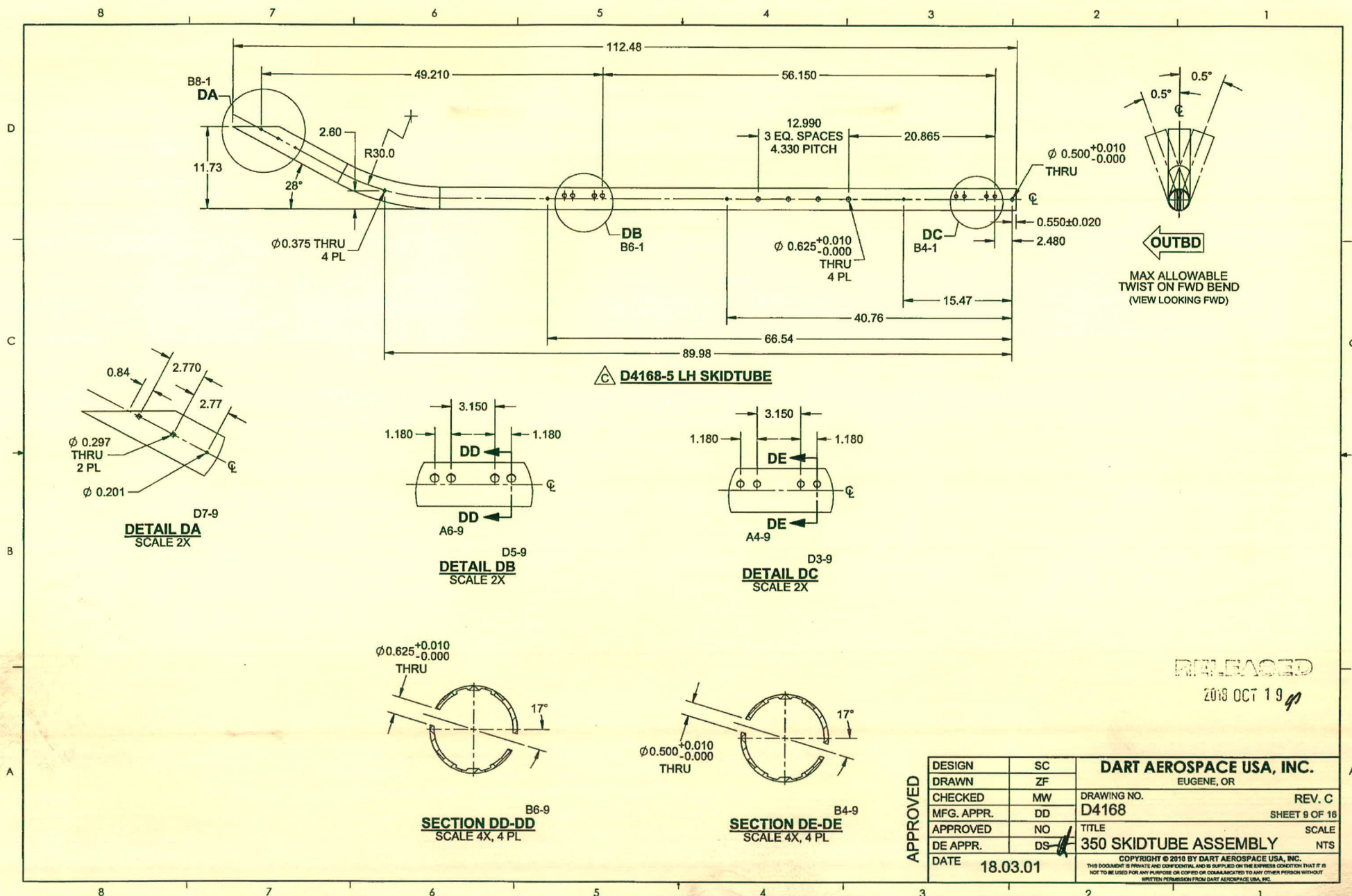
SECTION AF-AF
SCALE 4X, 4 PL

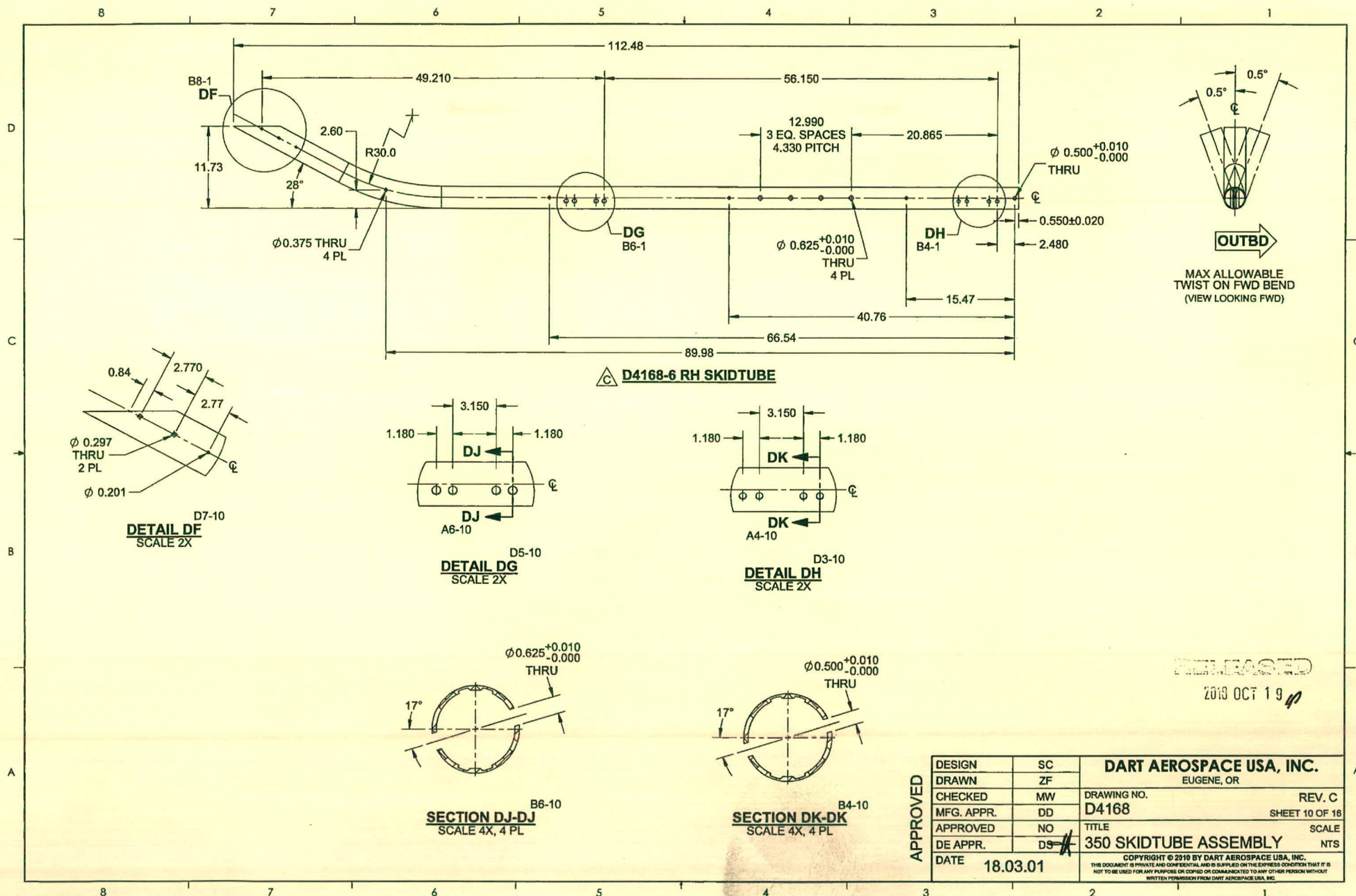
RELEASED

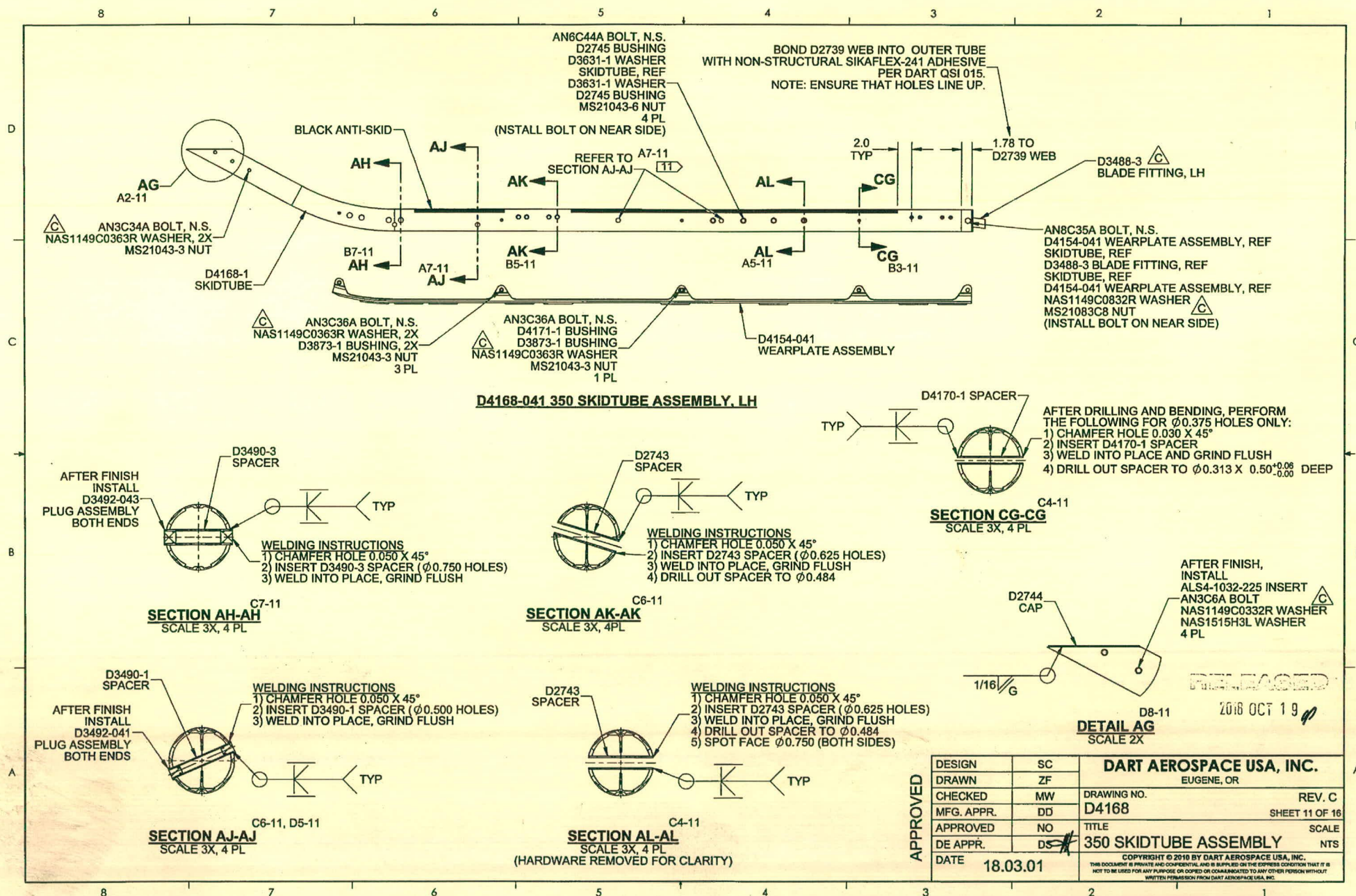
2010 OCT 19

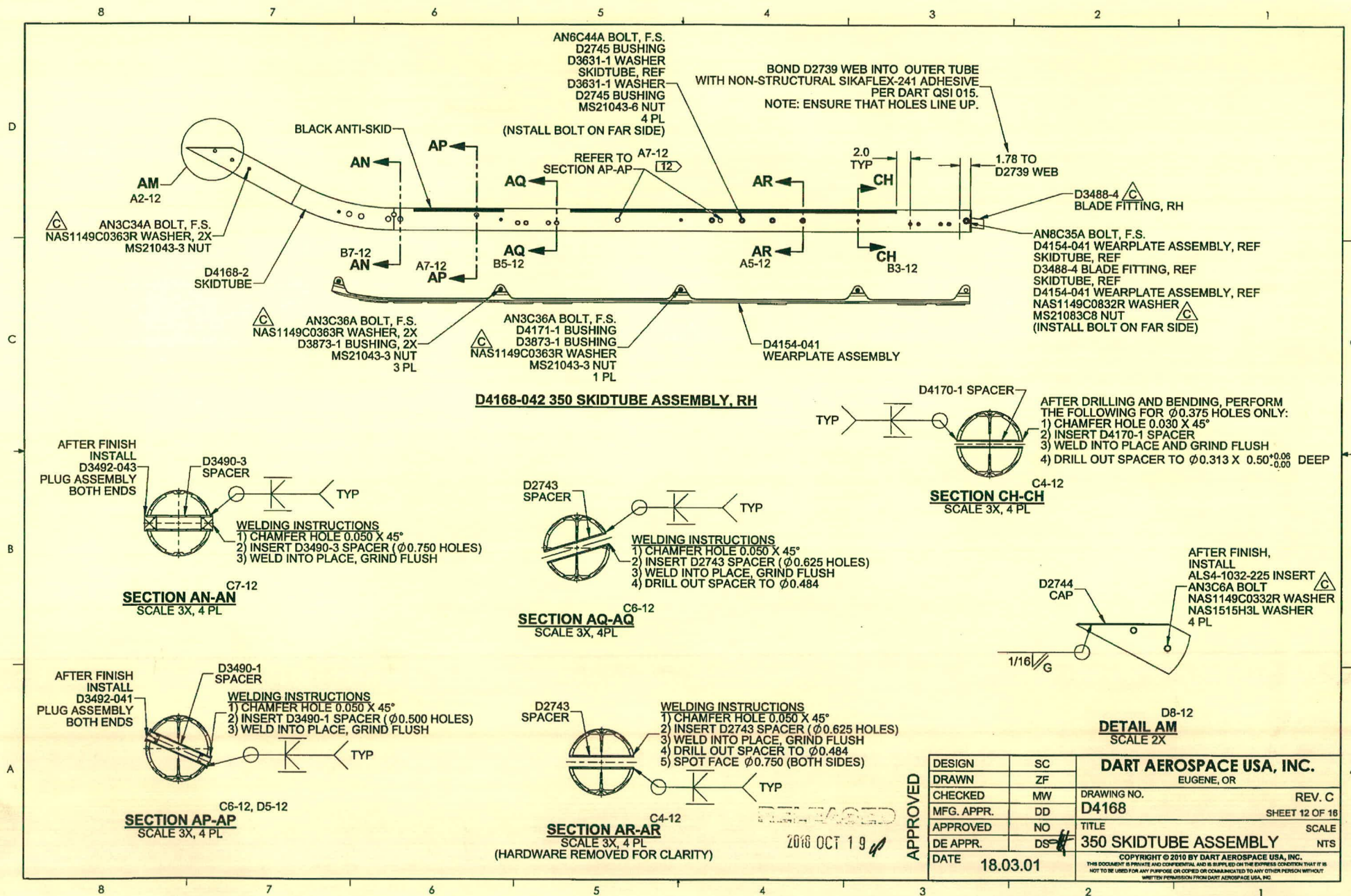
APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 8 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

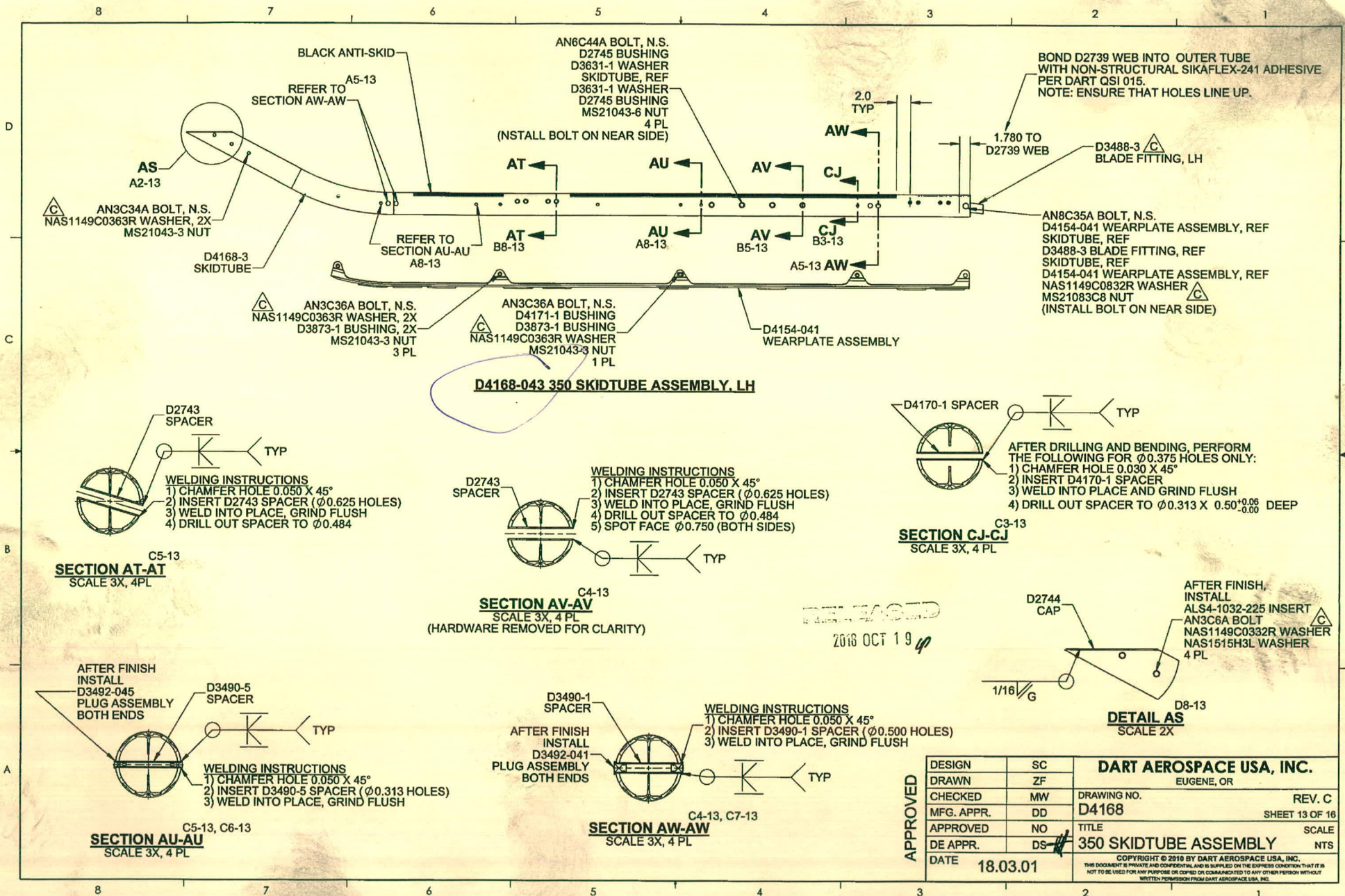


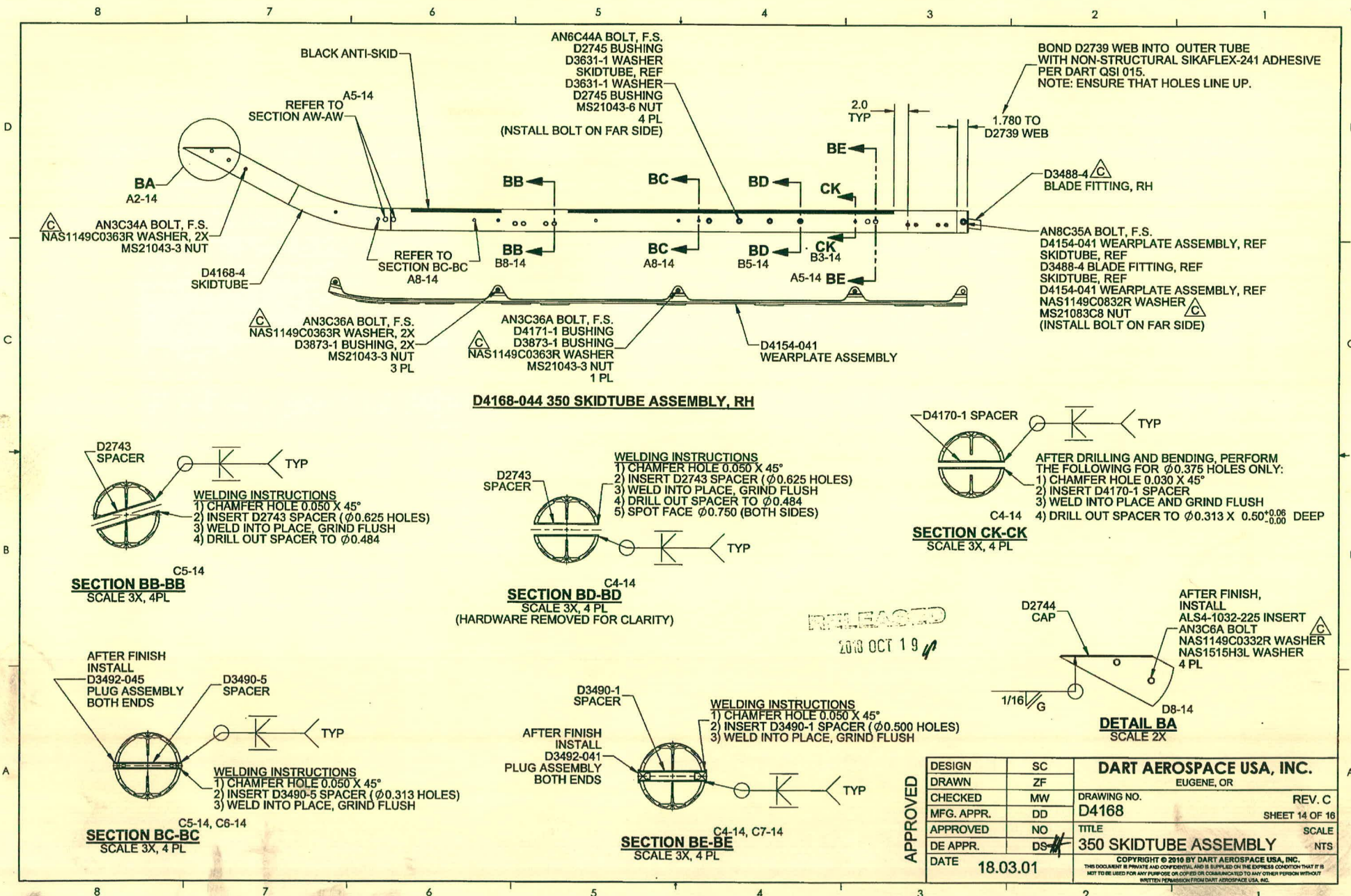


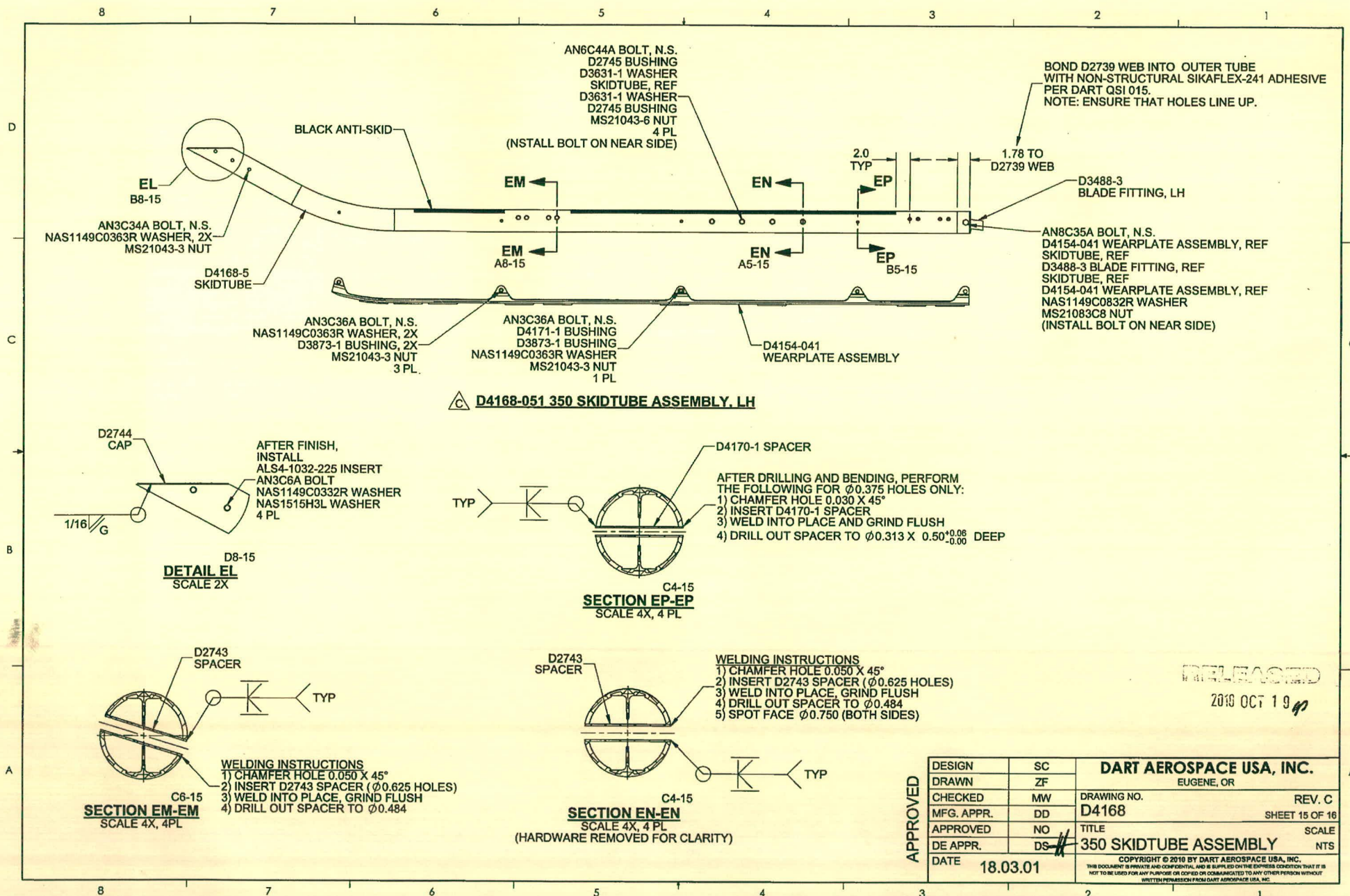


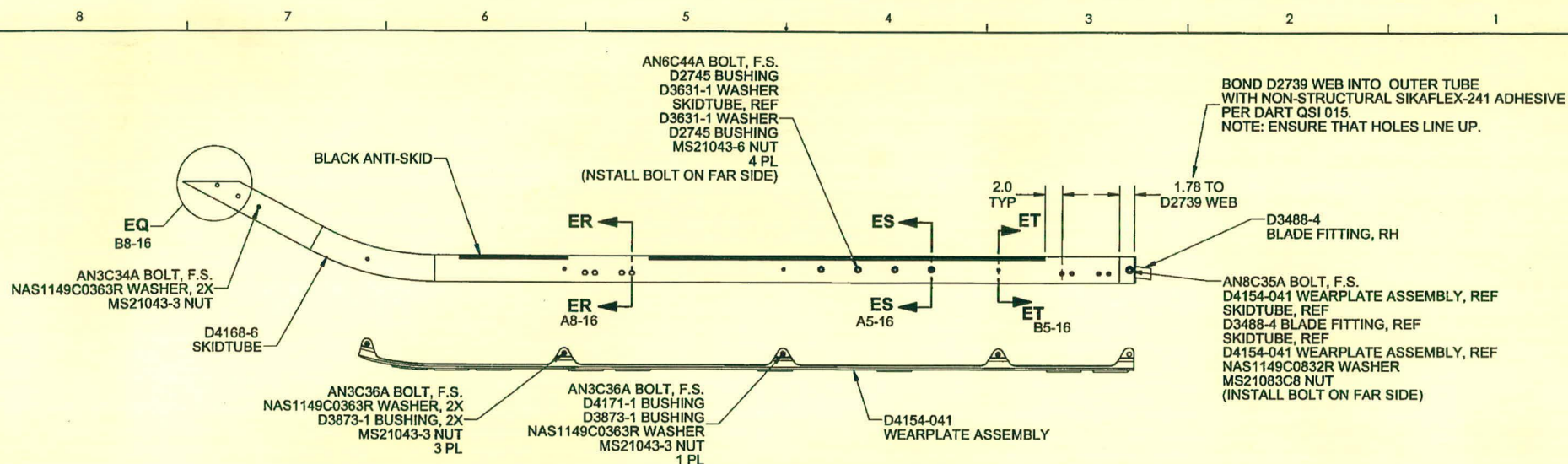




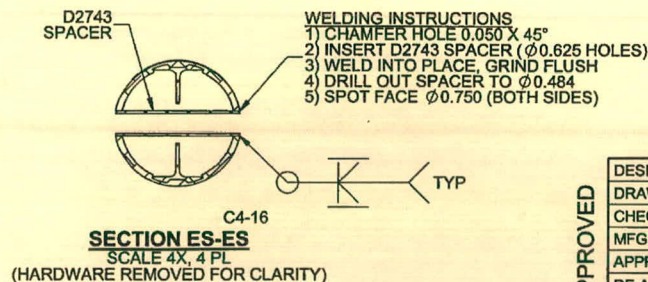
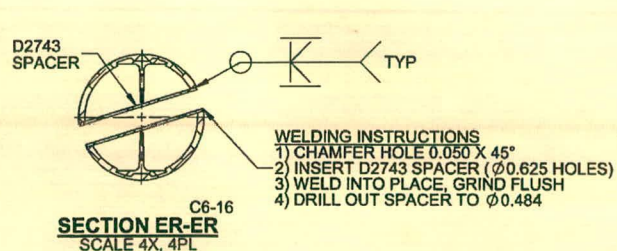
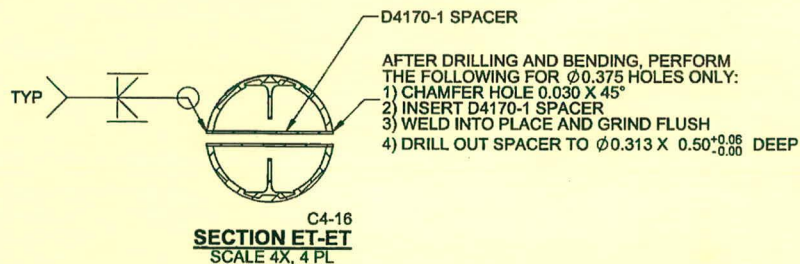
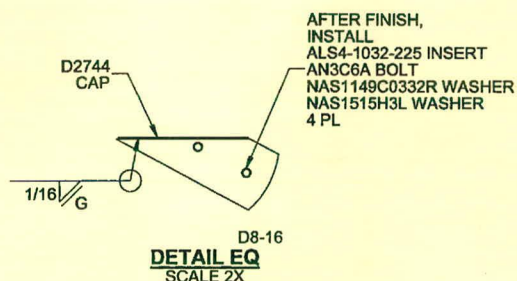








D4168-052 350 SKIDTUBE ASSEMBLY, RH



APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 16 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2010 OCT 19



Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042028**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO042028
PO Date: 12/12/18
Due Date: 12/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177515	D350-636-011	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	186338	D350-636-016	AS350/355 - Skidtube - Float w/ Heavy-Duty Wearplates - RH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042028**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186804	D350-636-018	Skidtube RH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 (Spray Paint / NDT Room), Spray Painting per QSI005 4.2 Issue P/O to Atelier Debosselage: _____ Spray Painting per QSI005 4.2 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
4	187142	D350-636-022	AS350/355 - Skidtube - Standard w/ Standard Wearplates - RH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
5	184463	D3391-025	Aft Tube Assembly : Various STC's PRIME AS PER DWG AND QSI005 4.2.1.3.3	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$125.00/pcs	\$125.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042028**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	186337	D350-636-015	AS350/355 - Skidtube - Float w/ Heavy-Duty Wearplates - LH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	185343			Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							2	0	2		\$450.00
7	187138	D350-636-021	AS350/355 - Skidtube - Standard w/ Standard Wearplates - LH : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	187135			Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	187137			Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							3	0	3		\$675.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042028

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	186803	D350-636-017	Skidtube LH, Run-on Landing, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 ISSUE P/O: _____ Spray Painting per QSI005 4.2 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____ C OF C IS REQUIRED	Firmed	-	12/18/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00

EX DEC 17 2018

Grand Total: \$2,375.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 9:49 AM dart.tsimiklis.chrisoula

